

**Work Order ID 57929**

Tuesday, April 20, 2010 11:12:59 AM



Page 1

Item ID: D3763-041

Accept



Setup Start



Revision ID:

Item Name: End Fitting Assembly

Stop



Start Date: 4/20/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 4/23/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 10-4-20

QC:

Date:

Tooling:

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D3763	Rev B

100 Pick Kit

0.00

*K 10-05-05*
*10 ♂*


Packaging

Memo

0.00

Packaging

110



Large Fab

0.00

Large Fab

Memo

0.00

1-make a 0.063" chamfer on D3763-1 fitting before ass'y  
 2-assemble as per  
 dwg D3763 using locating pin DT9039  
 \*\*\*ensure locating pin is in  
 0.221" hole\*\*\*  
 3-weld as per dwg D3763 QSI004  
 Alum.  
 rod Batch: *M111311*

*10 ♂*

120



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

*K 10-04-27*
*(10) 10-04-27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



QC

Quality Control

Operation  
Description

QC5- Inspect part completeness to step on W/O

Set Up/  
Run Hours

0.00

S104/28

Draw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

M 10/04/29

(X10)

g

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10-blk 10-4-29.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Item ID: D3763-041

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Setup

Start



Revision ID:

Item Name: End Fitting Assembly

Stop



Start Date: 4/20/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 4/23/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

160



Packaging

Packaging

Operation  
DescriptionIdentify as per dwg & Stock Location: 26/ASet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*PC 4/20/10 (10)*



Quality Control

Memo

0.00

*10/05/10 (D)*

*BB 10-5-04  
(10)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Tuesday, April 20, 2010 11:12:59 AM

Page 1

Work Order ID: 57929



Parent Item: D3763-041



Parent Item Name: End Fitting Assembly

Start Date: 4/20/2010

Required Date: 4/23/2010

Comments: IPP Rev:A 08-05-20 new issue DD verified by:cc  
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC  
IPP Rev:C 08-08-11 add chemical coat and qc3 DD verified by:EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3763-1		Manufactured	No			110	Each	5.0000	10.0000		<i>Sk 10-04-27</i>	

End Fitting



## Warehouse Loc Qty Loc Code

### Location

Main Warehouse

WA *357931*

5

*10*

56755

5

*10*

D3763-3



Manufactured No

110

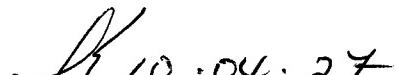
Each

.6.0000

10.0000



*10*



Tube

## Warehouse Loc Qty Loc Code

### Location

Main Warehouse

ST251 *357930*

6

*10*

56597

2

*10*

57553

4

*10*

*10*

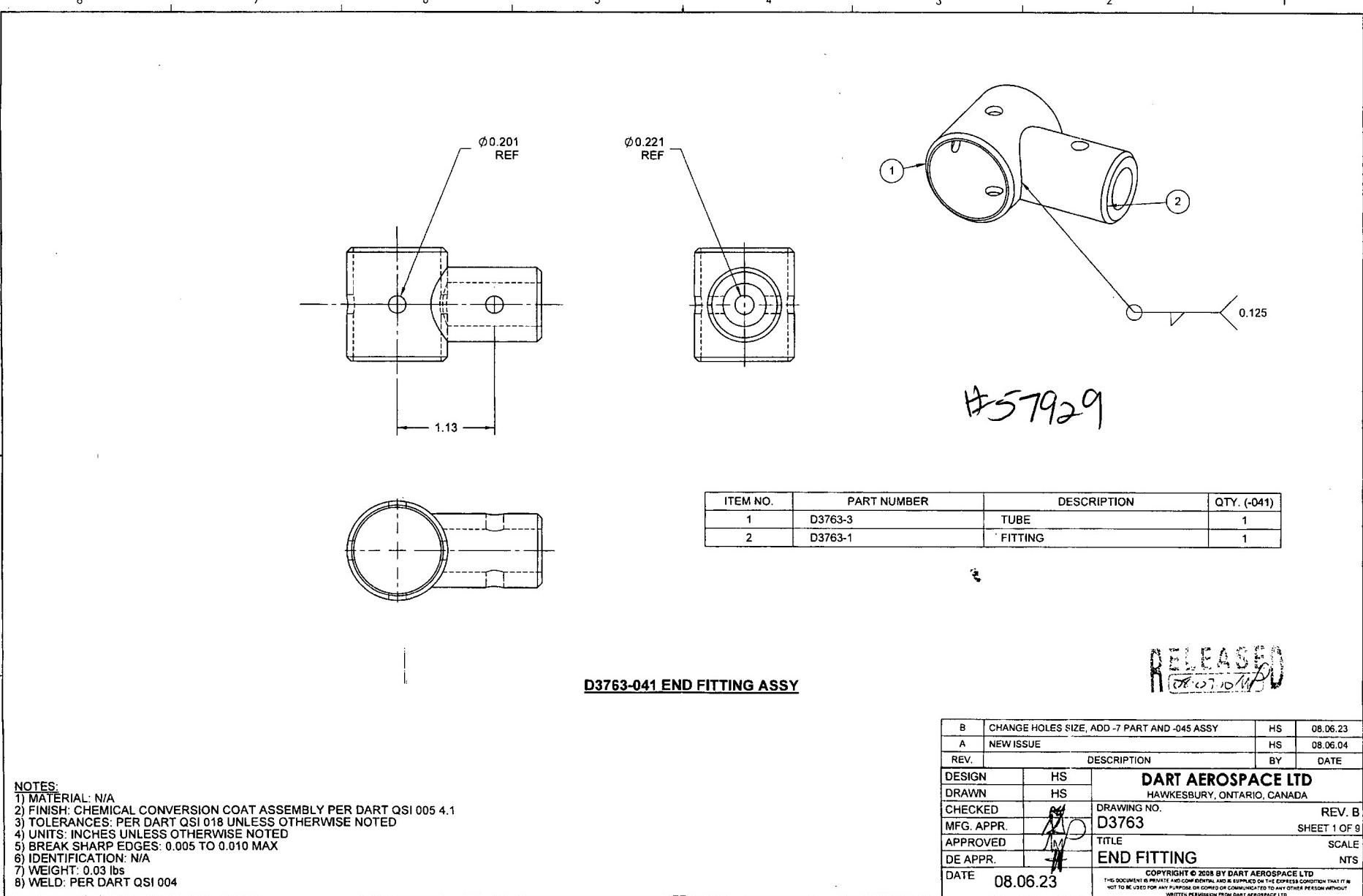
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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B	CHANGE HOLES SIZE, ADD -7 PART AND -045 ASSY		HS	08.06.23
A	NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION		BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	HS			
CHECKED				
MFG. APPR.		DRAWING NO. REV. B <b>D3763</b> SHEET 1 OF 9		
APPROVED		TITLE SCALE <b>END FITTING</b> NTS		
DATE	08.06.23			

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